

Work Order ID 84936

84936

May-29-12 3:01:03 PM

Page 1

Item ID: D209-669-043

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Replacement Skidtube

Stop

NS2

Start Date: 29/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/29 Tooling:

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2906	Rev B								

100 0.00

100 DOCUMENT CONTROL

DC Memo 0.00

Document Control Photocopy D209-669 bluefile & type labels per PPP D205-669-043 Chg 002 per ECN 12-509

110 0.00

110 Skidtubes

Memo 0.00

Skidtubes - Inspect mat'l D2500-1-190 for damage

- Drill pilot holes using drill jig DT8149, DT8711-2 & DT8711-3 (Do not use cutting fluid)

- Open holes to 0.500" as per Dwg D2906 without cutting fluid

- Deburr and blow out all chips from

- Acid etch and Alodine tube per QSI 005 4.1

> CF 12-6-11

> SA 12-06-11

CF 12-6-11

W/O: 84936

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D209-669-043 PAR #: _____ Fault Category: Skid tube NCR: Yes No DQA: *[initial]* Date: 12/07/17
 Resolution: _____ Disposition: *well as is* QA: NC Closed: *[initial]* Date: 12/7/17

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/6/18	140	Tube is over bent. fwd = 2.185 aft = 1.560 RC!	<i>GP</i> 12/6/18	Acceptable	<i>MVR</i>	<i>DAS 16 S-C</i> 12/6/18	<i>GP</i> 12/6/18	<i>DAS 16 S-C</i> 12/6/18

NOTE: Date & initial all entries

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Revision ID:

Item Name: Replacement Skidtube

Stop

NS2

Start Date: 29/05/2012 Start Qty: 1.00

1

Required Date: 16/07/2012 Req'd Qty: 1.00

1

Cust Item ID:

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC	QC3- Inspect Part Finish <i>Act</i>	0.00							<i>① SAD 206 R</i>
Quality Control	Memo	0.00							

130

130

Skidtubes

Skidtubes

0.00

1 CF 12-6-11

Memo 0.00

-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 *M121469*Sikaflex expire date: *13-4-12*Start Time: *17:15* Date: *12-6-11*Fin Time: *7:00* Date: *12-07-09*

pick:

Qty P/N description
1 D2926-3 WebB/N
84936

W/O: 24936

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12.06.11	120	change QC 3 to QC7	SAD			120611	2013-06-12

Part No: D 209-669-03 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start

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Item Name: Replacement Skidtube

Stop

NS2

Start Date: 29/05/2012 **Start Qty:** 1.00

1

Cust Item ID:

Required Date: 16/07/2012 **Req'd Qty:** 1.00

1

Customer:

Reference:

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	*NR1*
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170		0.00							
170	Large Fab								
Skidtubes	Memo	0.00							
Skidtubes	-Drill holes for wearplates using DT8217 Open holes to 19/64", adjust stopper not to hit web. Deburr								
	-Drill pilot holes for aft & fwd cap using DT8215 open holes to #6" Deburr								
	-Drill pilot holes for Tow ring using DT8091-3 , open to .640" and Deburr								
190	QC5- Inspect part completeness to step on W/O	0.00							
190	Memo	0.00							
QC									
Quality Control									

12-7-9

S1702109

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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1

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 *200* HandFinish	Pressure Wash per QSI005 4.3	0.00							

200 HandFinishing	Memo	0.00				1	76	12.7.9	
-------------------------------	------	------	--	--	--	---	----	--------	--

210 *210* Powdercoat	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----------------------------------	--	------	--	--	--	--	--	--	--

Powder Coating <i>m121841</i>	Memo	7-20	0.00						
	START TIME:	3200	01						
	OVEN TEMPERATURE:								
	FINISH TIME:	7-50							

220 *220* QC	QC3- Inspect Part Finish	0.00							
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Quality Control	Memo	0.00				1	8	12/07/11	
-----------------	------	------	--	--	--	---	---	----------	--

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Accept

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Setup

Start

NS1

Revision ID:

Item Name: Replacement Skidtube

Stop

NS2

Start Date: 29/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

240 QC5- Inspect part completeness to step on W/O

0.00

240

QC

Quality Control

Memo

0.00

8/12/07/12

(A)

250

250

Packaging

Packaging

Memo

0.00

8/12/07/12

Packaging

Identify and pack for shipping as per PPPD209-669-043

Location:

PPP Rev:

PDI 84913

260

260

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

MLJ 12/07/23

MLJ 12/07/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 84936

84936

D209-669-043

Parent Item: D209-669-043

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: new IPP 08.02.13 LL, verified by: DD
IPP Rev:B remove DT# in seq140 DD 10.03.10 Verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1		Manufactured	No				Each	81.0000		19			

D4202-1

Spacer

Location	B 832 63	Loc Qty	Loc Code
LG		5	
	77727	5	
LG002		76	
	78806	6	
	79810	70	

D2500-1-190

D2500-1-190

Ext'n - I' Beam Tube 4"

Location	Loc Qty	Loc Code
HALL	91	
74777	14	
80061	77	

D2926-3

D2926-3

Web

Manufactured	No	110	Each	0.0000	1	1
--------------	----	-----	------	--------	---	---

B 84950

**

① CF 12-6-11

D2855

D2855

Cap

Manufactured	No	230	Each	21.0000	2	2
--------------	----	-----	------	---------	---	---

**

2 ② 12/07/11

X

Location	Loc Qty	Loc Code
FP002	21	
65519	2	
73347	16	
75074	3	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 2

Work Order ID: 84936

84936
D209-669-043

Parent Item: D209-669-043

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3-5A

Purchased

No

230

Each

1,090.000

4

4

**

4

(2)

12/07/11

AN3-5A

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST350	1090	
115371	46	
117423	124	
118626	31	
119355	200	
120187	500	
121185	189	

AN960JD10L

NAS1149D0332J ✓ Purchased

No

230

Each

0.0000

4

4

**

4

(2)

12/07/11

***AN960.JD10I ***

Washer

ALS7-1032-130

Purchased

No

230

Each

2,136.000

44

44

**

44

(2)

12/07/11

AL S7-1032-130

Insert

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST280	51	
117717	27	
118966	22	
119775	2	
ST282	2085	
119530	73	
120181	12	
121444	2000	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 84936

84936

Parent Item: D209-669-043

D209-669-043

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

230

Each

1,458.000

44

44

**

44

(2P)

12/07/11

AN3C4A

BOLT

Location	Loc Qty	Loc Code
ST350	122151	
120187	57	
120521	28	
120769	38	
121205	1000	
121556	335	

AN960C10L

~~NAS1149C0332~~ Purchased

No

230

Each

0.0000

44

44

**

44

(2P)

12/07/11

*AN960C10I *

washer

D2594-3

Manufactured

No

230

Each

2,418.000

14

14

**

14

(2P)

12/07/11

D2594-3

O-Ring, 205 Skidtube

Location	Loc Qty	Loc Code
FP001	2418	
65518	41	
79496	984	
79573	50	
79755	1343	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B				Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 84936

84936

Parent Item: D209-669-043

D209-669-043

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D2594-1

Manufactured

No

230

Each

311.0000

14

14

**

14

(SP)

12/07/11

D2594-1

Plug, 205 Skidtube

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001 84951✓	98	
73401	30	
74442	18	
79495	50	

FP-A	213	
73401	0	
78590	213	

D3564-9

Manufactured

No

230

Each

22.0000

1

1

**

1

(SP)

12/07/11

D3564-9

Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG 84870✓	4	
76950	4	
FP001	18	
67590	4	
69943	1	
82255	13	

D3564-11

Manufactured

No

230

Each

8.0000

1

1

**

1

(SP)

12/07/11

D3564-11

Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG 83910✓	4	
77056	4	
FP001	4	
80341	4	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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D209-669-043

Parent Item: D209-669-043

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

230

Each

13.0000

1

1

**

1

(SP)

12/07/11

D3564-5

Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG 84869✓	2	
34806	2	

FP001	11	
77609	3	
82254	8	

D3566-1

Manufactured No

230

Each

31.0000

2

2

**

2

(SP)

12/07/11

D3566-1

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP 86240✓	22	
81619	10	

FP002	53	
68924	2	
80919	3	
83898	16	

D3566-5

Manufactured No

230

Each

21.0000

1

1

**

1

(SP)

12/07/11

D3566-5

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	12	
82275	12	

FP002	9	
80374	3	
82274	6	

84881✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

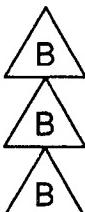
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

QTY -041	QTY -043	Part Number	Description
X		D2906-041	SKIDTUBE ASSEMBLY
	X	D2906-043	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
22	19	D2579	CROSS BOLT SPACER
12	14	D2594-1	PLUG
12	14	D2594-3	O-RING
2	2	D2855	AFT CAP
1		D2926-1	WEB
	1	D2926-3	WEB
1	1	D3564-9	WEARSHOE (REPLACES D2577-1)
1	1	D3564-11	WEARSHOE (REPLACES D2577-3)
1	1	D3564-5	WEARSHOE (REPLACES D2577-5)
1		D3564-15	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1		D3566-15	GASKET
50	44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
50	44	AN3C4A	BOLT
4	4	AN3-5A	BOLT
50	44	AN960C10L	WASHER
4	4	AN960JD10L	WASHER



GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES.
- 3) INSERT D2926-1/-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 6) USE DART DRILL TEMPLATE DT2906-041T1 (D2906-041) OR DT2906-043T1 (D2906-043) TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION C-C AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/291.
- 7) WELDING TO BE DONE PER DART QSI 004.
- 8) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2926-1/-3 WEB. POWDER COAT ASSEMBLY WHITE (REF 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 9) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (12 PLACES).
- 10) ALL DIMENSIONS ARE IN INCHES.

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84936 *mcj*
12/05/29

RELEASED

07-09-04 *[Signature]*

B	UPDATE DRAWING FORMAT; RE-ORGANIZE; ADD STAINLESS STEEL WEARPLATES AND GASKETS CHANGE WEARPLATE HARDWARE TO SS; PG 1: ADD NOTE 10; PG 2 C7: REMOVE AFT Ø0.640 HOLE FROM -041; PG 3 C3: CORRECTED -043 CAP P/N; PG 3 D7: 38 PLACES WAS 44 PLACES;	CB	07.08.21
A	NEW ISSUE	CP	04.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>qf</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>CB</i>		
CHECKED	<i>PH</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>91</i>	D2906	SHEET 1 OF 3
APPROVED	<i>100</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AH-1 (209) SKIDTUBE ASSEMBLY	NTS
DATE	07.08.21	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

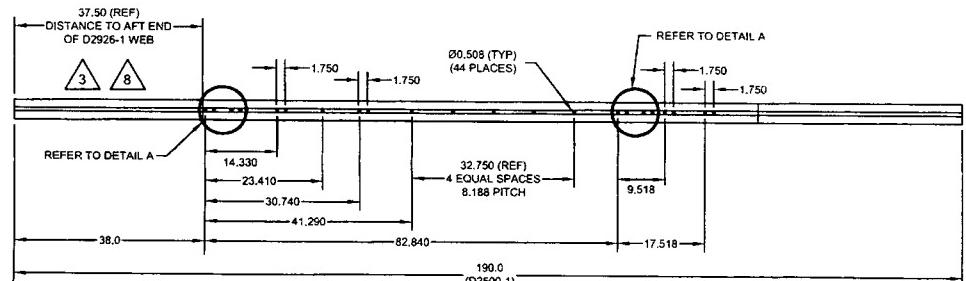
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

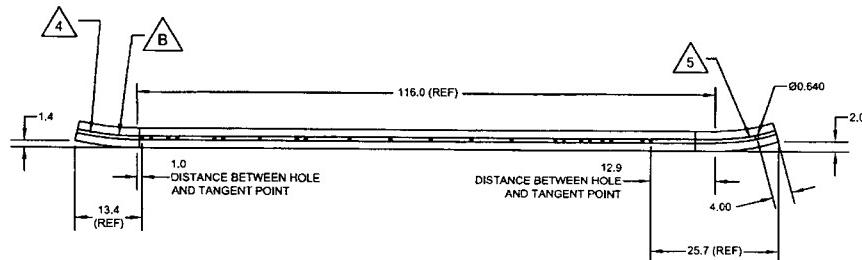
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

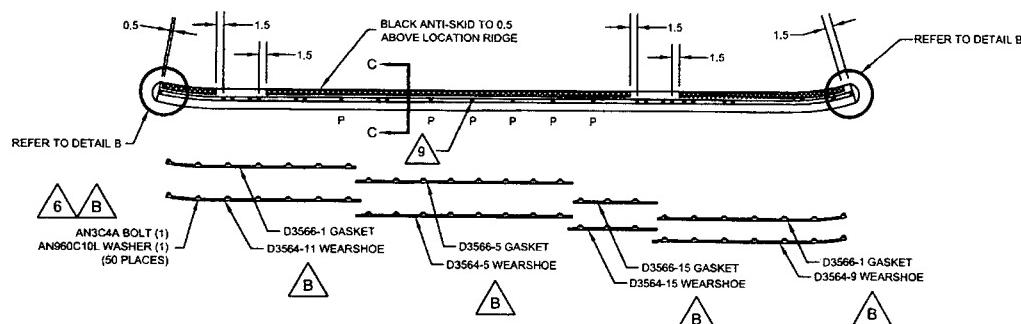
NOTE: Date & initial all entries



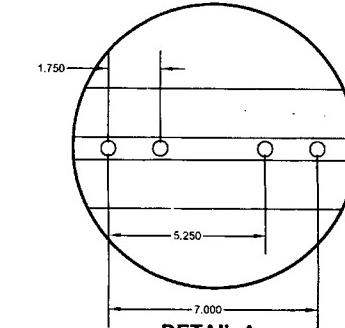
D2906-1 DRILLING DETAIL



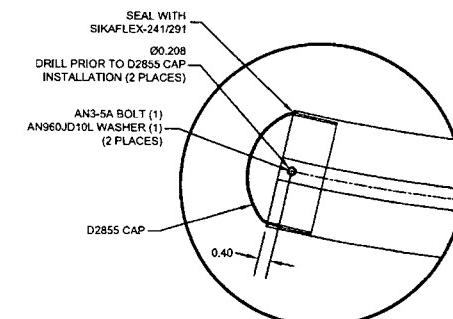
D2906-041 BENDING AND CUTTING DETAIL



D2906-041 ASSEMBLY DETAIL

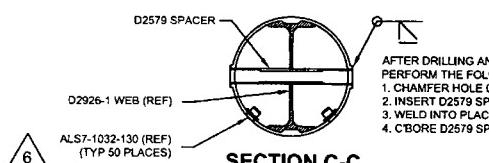


DETAIL A
SCALE 1:4



DETAIL E
SCALE 1:4

RELEASED



SECTION C-C

DESIGN	<i>DP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	<i>CB</i>			
CHECKED	<i>PH</i>	DRAWING NO.	REV. B	
MFG. APPR.	<i>SI</i>	D2906	SHEET 2 OF 3	
APPROVED	<i>HP</i>	TITLE	SCALE	
DE APPR.	<i>-</i>	AH-1 (209) SKIDTUBE ASSEMBLY	1:24	
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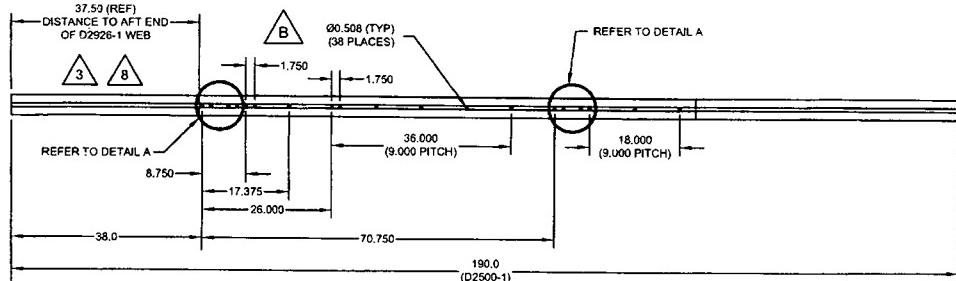
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

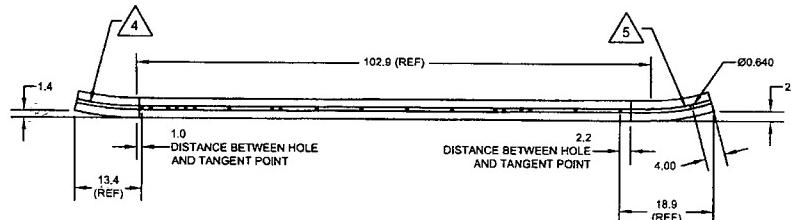
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

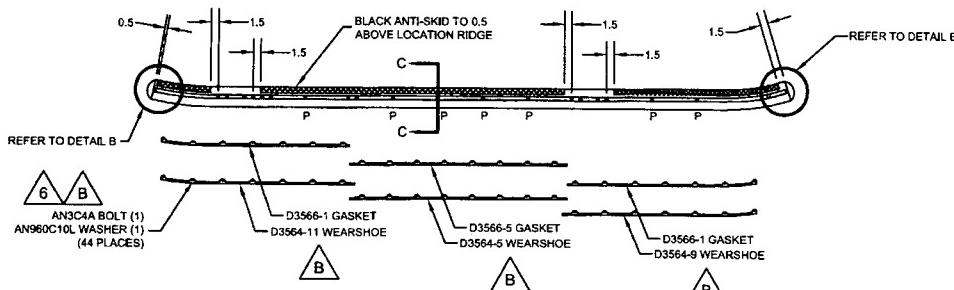
NOTE: Date & initial all entries



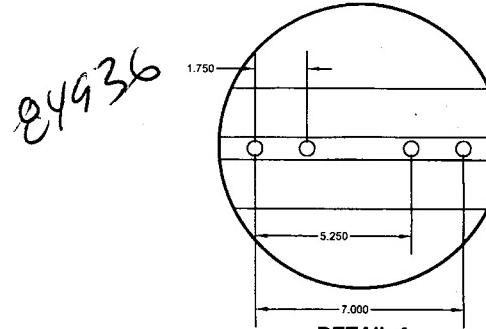
D2906-3 DRILLING DETAIL



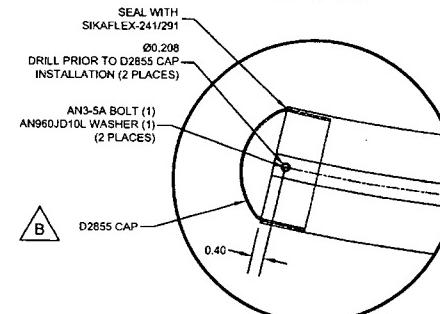
D2906-043 BENDING AND CUTTING DETAIL



D2906-043 ASSEMBLY DETAIL

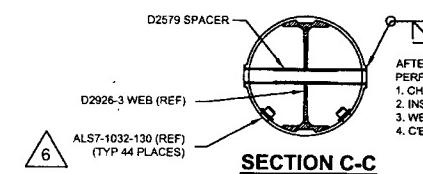


DETAIL A
SCALE 1:4



DETAIL B
SCALE 1:4

RELEASED



SECTION C.
SCALE 1:1

**AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:**

- 1. CHAMFER HOLE 0.050 X 45°**
- 2. INSERT D2579 SPACER (22 PLACES)**
- 3. WELD INTO PLACE AND GRIND FLUSH**
- 4. CBORE D2579 SPACER TO #0.437 X 1.00 DEEP**

DESIGN	<i>99</i>	DART AEROSPACE LTD HAWKSLEY, ONTARIO, CANADA		
DRAWN	<i>CB</i>			
CHECKED	<i>PH</i>	DRAWING NO.	REV. B	
MFG. APPR.	<i>SI</i>	D2906	SHEET 3 OF 3	
APPROVED	<i>HP</i>	TITLE	SCALE	
DE APPR.	<i>TT</i>	AH-1 (209) SKIDTUBE ASSEMBLY	1:24	
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NOTE: Date & initial all entries